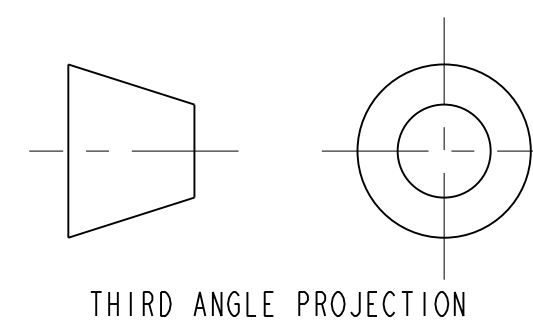


NOTES: (UNLESS OTHERWISE SPECIFIED)

1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF  $\pm 0.063$ ".
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.

SCALE 5 / 16



D	R/LM	J/PZ	10/16/93	90° WAS 109°	
C	R/LM	J/PZ	6/9/93	P2.25 WAS R3.5, PIPE CALL OUT CHANGE	
B	ARRH	SPV	8/15/93	MINOR DRAWING DIMENSIONAL CHANGES, REVISED DRAWING NOTE 16, ADDED CENTER SUPT DWM.	
A	ARRH	SPV	11-04-02	INITIAL RELEASE	
REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED	
TOLERANCES	
X.X ± 0.1	FRAC. ± 1/64
X.XX ± 0.03	Angles ± 1.00°
X.XXX ± 0.010	FINISH 125 $\sqrt{Ra}$

DO NOT SCALE PRINT

THREADS ARE CLASS 2


CUTTER ROUNDS OF ALL SCREW THREADS 30°

CHAM FEND, 1.5 THREAD RELIEF ON MACHINED THREAD

BREAK EDGES 0.05 MAX. ON MACHINED WORK

REMOVE BURRS, WELD SPATTER & LOGGED MARK

IN ACCORDANCE WITH ASME Y14.5M & B46.1

6	-	I	PIPE, PER ASTM A312	SS 304L
5	-	I	PIPE, PER ASTM A312	SS 304L
4	-	I	SUPPORT COLLAR	SS 304L
3	-	I	BRAIDED FLEX HOSE, 2"ID X 6 1/2" LL	SS 300 SERIES
2	-	I	BRAIDED FLEX HOSE, 2"ID X 4" LL	SS 300 SERIES
1	-	I	PIPE, PER ASTM A312	SS 304L
ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
SHOP ORDERS			<div>ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY</div> <div>UNIVERSITY OF CALIFORNIA - BERKELEY</div> <div></div>	
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
ACQ. NO.	REQD	REQD		
LHC IR FEEDBOX CRYOGENICS PIPE WELDMENT, LD2				
MICROFILMED:			DWG. TYPE SHOWN ON SCALE: 1/4	SHEET 1 OF 2
ASSEM				
PATENT CLEAR:			DESIGN ACCT. NO. CATEGORY CODE DWG. NO. SIZE REV	
			251CE2 LH2003	2512456 D

